

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000521**Date Inspected:** 19-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**  
**Welding** **NDT****Welder Qualification** **Fracture Critical**  
**Mechanical Testing, describe:**Side bend, Macroetch, Charpy**Index Lot #:** NA**Witness Lot #:** B63-082-07**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Welder:****ID #:** HP2007519**Joint Description:**

N/A

**WPS ID #:**

N/A

**Base Metal:** SL345

N/A

**PQR ID #:**

N/A

**Thickness:** 28

N/A

**Process:**

SMAW

N/A

**Electrode Spec/Class:** THJ506FE-1 4 mm dia. (E7018)

N/A

**Positions:**

1T

N/A

**Backing Material:** ASTM A709 (345)

N/A

**CWI:**

Huang Wei

N/A

**Average Amps:**

N/A

**AWS Code:**

AWS D1.5 2002

N/A

**Average Volts:**

N/A

**Applicable Sec:**

5.13

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

American Bridge Weld Engineer Mr. Craig Knops informed the QA Inspector ZPMC has completed side bent testing and tensile testing of procedure qualification test (PQR) HP2007519 prior to the arrival of the QA Inspector and that the side bend specimens and macroetch specimens are visually acceptable. ZPMC QC CWI Inspector Mr. Huang Wei informed the QA inspector that the side bends and macroetch specimens are visually acceptable. Mr. Knops said Charpy testing will take place once the test pieces are cooled to a temperature of -30°C. Mr. Knops said ZPMC has an automated Charpy testing machine and prior to the loading of the Charpy samples into the machine he had confirmed all of the Charpy test coupons have been machined to the proper size and the notches are the correct depth. The QA Inspector observed testing of the Charpy coupons and following random visual inspections of the side bends and macroetch samples the QA Inspector assigned lot number B63-082-07 to PQR HP2007519.

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## WELDING WITNESS REPORT

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### Summary of Conversations:

#### Observed welding, testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson, Paul
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cochran, Jim
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QA Reviewer
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